

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003249**Date Inspected:** 11-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Keng Chan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara was present at jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Bay 1**Skin Plate A South Tower Assembly**

The Quality Assurance Inspector observed ZPMC welders 047338 and 068924, utilizing the shielded metal arc welding process on tack welds complete joint penetration in the horizontal position on longitudinal stiffener SSDI SA159 E/J 11B to skin plate A South Tower Assembly. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2312-TC-PS.

SSDI-SA178 A/D 4A

The Quality Assurance Inspector observed ZPMC welder 040434, utilizing the flux cored arc welding process on a complete joint penetration in the flat position on longitudinal stiffener weld number SSDI-SA178 A/D 4A. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

Ultrasonic Testing

The Quality Assurance Inspector performed 10% random ultrasonic testing verification on skin plate D South

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Tower Assembly. The Quality Assurance Inspector performed the testing on the following welds; SSDI SA180 C/C 6B, SSDI SA180 D/E 3B and SSDI SA180 D/E 24B. See Caltrans report TL-6027 Ultrasonic Testing Report, dated July 11, 2008 for additional information.

Bay 2

ESDI-SA216 H/K 7B

The Quality Assurance Inspector observed ZPMC welder 053316, utilizing the flux cored arc welding process on a complete joint penetration in the flat position on longitudinal stiffener weld number ESDI-SA216 H/K 7B. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

P589B

The Quality Assurance Inspector observed ZPMC welder 053316, utilizing the flux cored arc welding process performing butter up on longitudinal stiffener plate number P589B. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2231-B-U3-F.

Summary of Conversations:

No relevant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara,Raymond	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
